

Work Order ID 80156

February-13-12 7:58:34 AM

80156

Page 1

Item ID: D3167-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 13/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 12/02/13 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3167	Rev A1								

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File D3167-1_BLANK

B12-2-21

(4)

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Note: (2) Bearpaw for (1) Kit
1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA285 and Dwg D3167
3-Deburr

SL 12-03-13

(4)

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

SL 12/03/13

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80156

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Page 2

Item ID: D3167-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***

Start Date: 13/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: *PAP*

0.00

151

Packaging

Memo

80156

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

February-13-12 7:58:37 AM

Page 1

Work Order ID: 80156

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Parent Item: D3167-1

D3167-1

Parent Item Name: Bearpaw

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	668.5243	3.6	14.4			

MUHMWB10

UHMW 1" Black

**

18.12-2-21

Location	Loc Qty	Loc Code
MAT018	408.88	
120035	88.88	
120401	320	
MAT019	259.6443158	
117321	74.6	
117738	95.8	
117819	83.3	
118814	1.5	
119145	4.44431579	

120401

(4)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	20156
Description: Bearpaw		Part Number:	D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

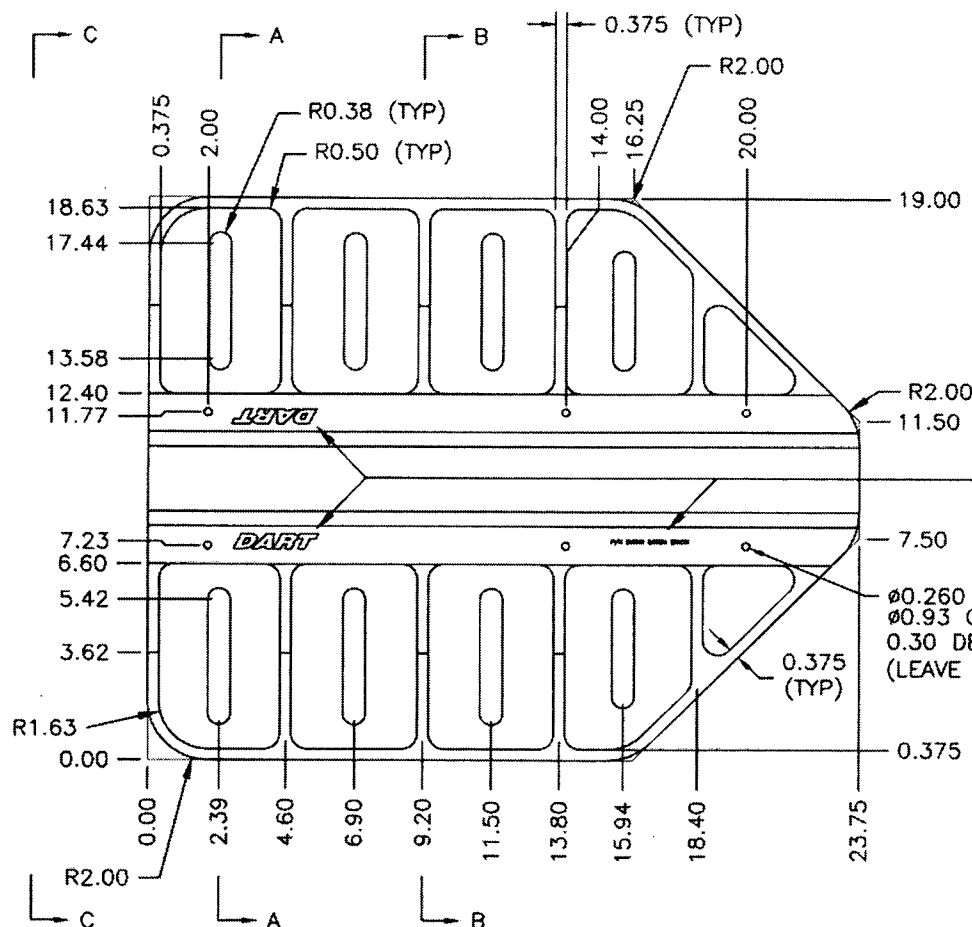
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.06 x 45°	✓		Vern	SL-3
B	5.80	+/-0.030	5.792	✓		"	
C	0.25 x 45°	+/-0.030	0.250 x 45°	✓		"	
D	R0.25	+/-0.030	.250	✓		R-G	
E	0.200	+/-0.030	.202	✓		"	
F	0.250	+/-0.010	.251	✓		"	
G	0.625	+/-0.030	.625	✓		"	
H	0.375	+/-0.010	.376	✓		"	
I	0.950	+0.030/-0.010	.955	✓		"	
J	3.21	+/-0.030	3.210	✓		"	
K	19.00	+/-0.030	19.00	✓		m-tape	
L	Ø0.260	+0.005/-0.000	.260	✓		Vern	SL-3
M	Ø0.93	+/-0.030	.926	✓		"	
N	0.30	+0.030/-0.000	.310	✓		"	
O	0.375	+/-0.030	.376	✓		"	
P	7.23	+/-0.030	7.229	✓		H-G	
Q	4.54	+/-0.010	4.540	✓		Vern	SL-3
R	2.00	+/-0.030	2.015	✓		"	
S	12.000	+/-0.010	12.000	✓		m-tape	
T	6.000	+/-0.010	6.000	✓		"	
U	23.75	+/-0.030	23.75	✓		m-tape	

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	12-03-13	Date:	12/03/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A
CHECKED	APPROVED	DRAWING NO.	D3167	SHEET 1 OF 2	
DATE		TITLE	BEARPAW	SCALE	1:6
02.10.08					
A	02.10.08	NEW ISSUE			
A1	02.12.17	5.80 WAS 5.50			



D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
02.10.25

100-80156 M.C.J.
12/02/13

W/O:		WORK ORDER CHANGES					
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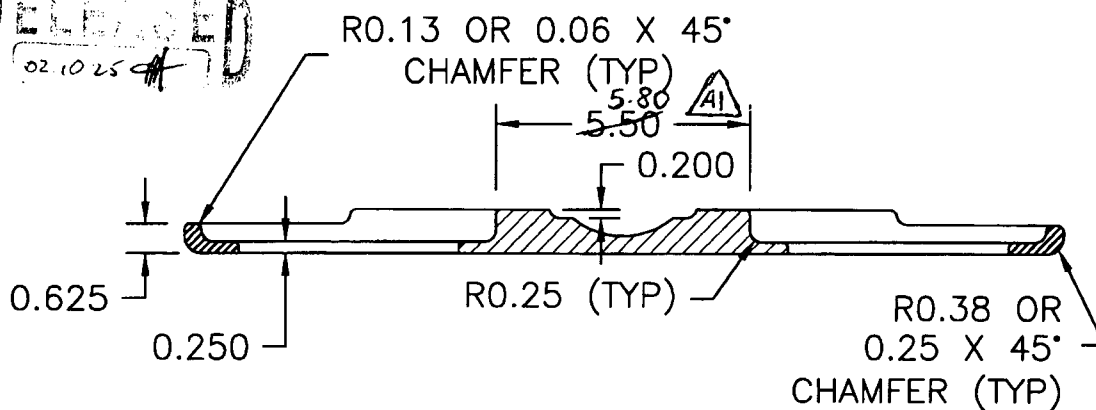
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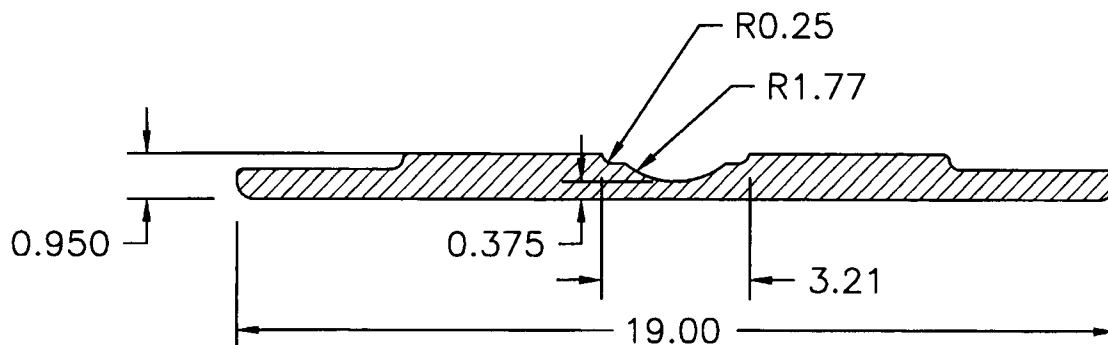


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

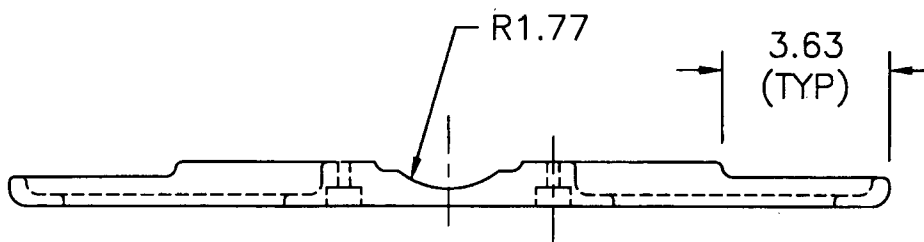
02 10 25



SECTION A-A



SECTION B-B



SECTION C-C

80156

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